

Work Order ID 99891 -2

Friday, April 12, 2013 3:26:47 PM

\*99891\*

Page 1

Item ID: D4125-3

Revision ID:

Item Name: End

Start Date: 4/12/2013 Start Qty: 6.00

Required Date: 4/19/2013 Req'd Qty: 6.00

Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: MUF

QC:

Date: 13-4-12

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4125

C

100

0.00

\*100\*

Bandsaw

Jeaspa Bandsaw

Memo

1-Cut Blank at 6.500"

0.00

PD

13/04/25

10

0

105

0.00

\*105\*

HAAS I

HAAS CNC vertical machine #1

Memo

Machined as per folio FB079

Rev: C

Dwg: C

Deburr

0.00

PD

FK 13/04/27

10

2

9

PTO

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA *Ante* Date: 13/05/22QA Closed: *ck* Date: 13/1/17

Work Order: <u>99891-2</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D4125-3</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>13-2633</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator	12/04/21	105	1	Modified program manually, because required tool for the job broke, the modified program had one issue therefore 1 part was scrap.	<i>DAS 16</i> <i>Q2L02</i> <i>13/04/20</i>	Scrap + Destroy  <i>228.44</i>	<i>FK</i> <i>19/04/27</i>	<i>SL</i> <i>13-43</i>	<i>DAS 16</i> <i>Q2L02</i> <i>13/04/20</i>
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

## FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input checked="" type="checkbox"/> Other
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Work Order ID 99891

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\*99891\*

Page 2

Item ID: D4125-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: End

Start Date: 4/12/2013 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 4/19/2013 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

P.R. 13/04/27

10  
9

2

Quality Control

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

9

13-43

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

\*130\*

HandFinish

Memo

0.00

9 13-56

Hand Finishing

Work Order ID 99891

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Page 3

Item ID: D4125-3

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: End

Start Date: 4/12/2013 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 4/19/2013 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

QC3-Inspect Part Finish

0.00

\*140\*

QC

Quality Control

Memo

0.00

9

φ

DAS  
19  
2-83  
13-05-09

150

Identify as per dwg & Stock Location: W4.003 0.00

\*150\*

Packaging

Packaging

Memo

0.00

9

φ

13-05-09

160

QC21- Final Inspection - Work Order Release 0.00

\*160\*

QC

Quality Control

Memo

0.00

13/5/15  
MF  
13-5-13

# Picklist Print

Friday, April 12, 2013 3:26:47 PM

Page 1

Work Order ID: 99891

Parent Item: D4125-3

Parent Item Name: End

Start Date: 4/12/2013

Required Date: 4/19/2013

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.07.21 new issue DD verf:EC  
JFS verf:DD

IPP Rev:B 11/12/05 as per rev.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X08.000 6061-T6 BAR 2.00' X 8.00"		Purchased	No			100	f	4.7370	0.542	3.4231579			

PD 13/01/25

Location	Loc Qty	Loc Code
MAT005	4.737	
123089	0.085	
124443	3.252	
125034	1.4	

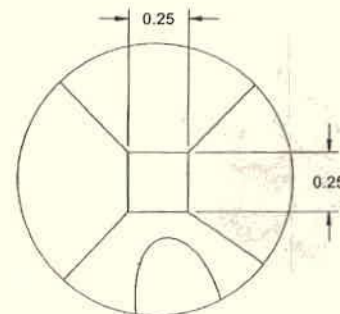
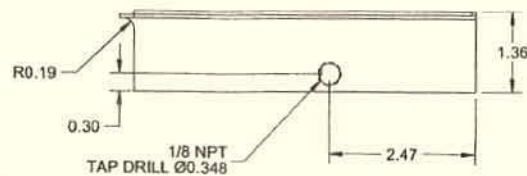
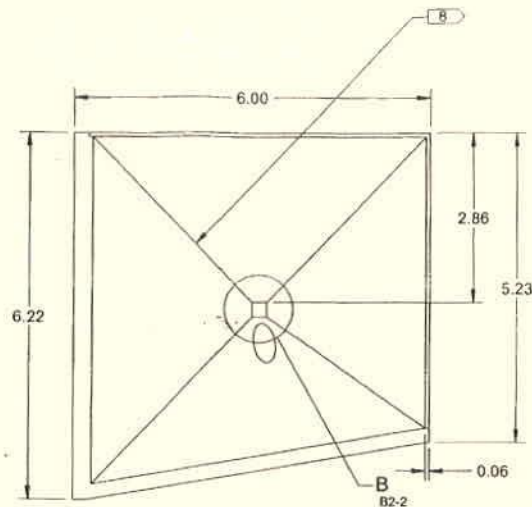
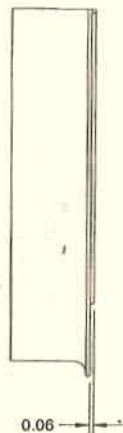
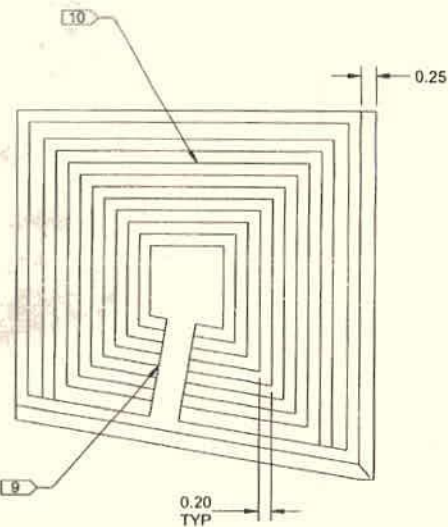
→ 125386  
12386

57  
5.6  
57

FK 13/04/28

FK: 13/04/28











**DETAIL B**  
**SCALE 4X**  
C4-2

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B1.750X6.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.16 lbs
- 8) MAXIMUM INSIDE RADIUS = 0.250
- 9) MINIMUM RADIUS = 0.187
- 10) MINIMUM RADIUS = 0.015

**C D4125-3 AFT SEDIMENT BOWL**

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4125	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SEDIMENT BOWLS	NTS
DATE	11.11.29	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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